

IN THE CLAIMS

Please amend the claims as follows:

1 (Currently Amended): A process for producing a turbine blade or vane having a longitudinal axis, comprising the steps of:

~~producing~~ providing the turbine blade or vane in a casting mold;

~~finishing the turbine blade or vane by fixing the casting in a first position, the first position corresponding to a predetermined position for the casting to be subjected to a pre-~~  
designed machining process;

~~subjecting the casting in said first position to an automatic material removing machining process being program controlled with respect to said first position, wherein a leading-edge angle of the turbine blade or vane which is altered in order to optimize the turbine is achieved by~~

~~rotating, prior to said material removing machining process, the casting around said longitudinal axis from said first position to a second position, and~~

~~subjecting said casting in said second position to said automatic material removing pre-designed machining process being program controlled with respect to said first position, while retaining the same casting mold~~ without modifying steps of said pre-designed machining process.

2 (Currently Amended): The process as claimed in claim 1, ~~further comprising the steps of~~ wherein:

said fixing step includes holding the casting in a holder during the machining process,  
and

said rotating step includes rotating the casting in the holder for the purpose of changing ~~the machining~~ a leading-edge angle of the turbine blade or vane, with [[the]] reference points required for the machining process being repositioned.

3 (Currently Amended): The process as claimed in claim 1, ~~further comprising the steps of wherein:~~

said fixing step includes holding the casting in a holder during the machining process,  
and

said rotating step includes rotating the casting together with the holder for the purpose of changing ~~the machining~~ a leading-edge angle of the turbine blade or vane, ~~the correctly~~ calculated distances being used to reach ~~[[the]]~~ desired positions.

4 (Currently Amended): The process as claimed in claim 1, further comprising the steps of:

providing an additional machining stock on the casting for the ~~material-removing~~ machining process, and

selecting the thickness of the additional machining stock to be sufficiently above a minimum value for it to be possible for a turbine blade or vane which has a leading-edge angle which can be selected freely within a predetermined range of angles to be produced by machining from the same casting.

5 (Previously Presented): The process as claimed in claim 4, wherein the casting for the turbine blade or vane has a blade or vane platform and a main blade or vane part, and the process further comprises the step of:

providing the additional machining stock above the minimum value on the blade or vane platform.

6 (Previously Presented): The process as claimed in claim 4, wherein:  
the minimum value for the additional machining stock is approximately 2 mm, and  
the additional machining stock above the minimum value amounts to a total of about 5 mm.